

Listing of Claims

1. (currently amended) A patient support apparatus comprising:
a base frame,
a patient support coupled to the base frame,
a plurality of casters each having a sleeve, and
a plurality of caster mounting tubes, each mounting tube including a plurality of external side walls surrounding an opening, each of the external side walls having an interior surface facing inwardly toward the opening and an exterior surface facing outwardly away from the opening, the interior surface being configured to receive in abutting relationship and to directly contact the sleeve of a caster, the plurality of external side walls including a generally planar first external side wall, a first exterior surface of the generally planar first external side wall abutting the base frame, the mounting tube being connected to the base frame by welds located adjacent the generally planar first external side wall.
2. (original) The apparatus of claim 1, wherein each of the plurality of caster mounting tubes has a rectangular outer cross-sectional shape defined by four external side walls.
3. (original) The apparatus of claim 1, wherein each mounting tube is coupled to the base frame by first and second welds located at opposite ends of the first external side wall.
4. (original) The apparatus of claim 3, wherein the first external side wall abutting the base frame is formed to include a hole, the base frame is formed to include a hole, the hole in the base frame is aligned with the hole in the first external side wall, and both holes are located between the first and second welds.
5. (original) The apparatus of claim 1, wherein the sleeve of each caster has a cylindrical shape and the plurality of caster mounting tubes each include interior partially cylindrical concave wall sections configured to receive one of the cylindrical sleeves.
6. (original) The apparatus of claim 5, wherein the each of the mounting tubes also includes a corner notch located between the concave wall sections.
7. (previously presented) A patient support apparatus comprising:
a base frame,
a patient support coupled to the base frame,
a plurality of casters each having a sleeve,

a plurality of caster mounting tubes, each mounting tube having an interior configured to receive the sleeve of a caster, a plurality of external side walls including a generally planar first external side wall abutting the base frame, the mounting tube being connected to the base frame by welds located adjacent the first external side wall, and

a plurality of set screws configured to orient the plurality of casters and wherein the caster mounting tubes are each formed to include an opening configured to receive one of the set screws.

8. (original) The apparatus of claim 1, wherein each of the caster mounting tubes has a square cross-sectional shape.

9. (original) The apparatus of claim 1, wherein the sleeve of each caster has a cylindrical shape.

10. (original) The apparatus of claim 1, wherein the sleeve of each caster has a rectangular cross-sectional shape.

11. (previously presented) A method for attaching a caster having a cylindrical sleeve to a base frame of a bed, the method comprising the steps of:

providing a caster having a cylindrical sleeve, a mounting tube having four side walls configured to provide an interior opening having a substantially rectangular cross-sectional shape, and a base frame of a bed having an outer surface;

removing material from the mounting tube such that at least a portion of the interior opening has a generally round cross-sectional shape to receive the cylindrical sleeve of the caster therein;

placing a first side wall of the mounting tube against the outer surface of the base frame;

welding the mounting tube to the base frame with first and second welds located at opposite ends of the first side wall; and

installing the sleeve of the caster into the interior opening of the mounting tube.

12. (previously presented) A method for attaching a caster having a cylindrical sleeve to a base frame of a bed, the method comprising the steps of:

providing a caster having a cylindrical sleeve, a mounting tube having four side walls configured to provide a substantially rectangular cross-sectional shape, and a base frame of a bed;

forming an interior opening through the mounting tube having a generally round

cross-sectional shape to receive the cylindrical sleeve of the caster therein;
placing a first side wall of the mounting tube against the base frame;
welding the mounting tube to the base frame with first and second welds
located at opposite ends of the first side wall;
installing the sleeve of the caster into the interior opening of the mounting
tube;
providing a set screw; and
forming an opening in the mounting tube to receive the set screw and orient
the caster.

13. (original) The method of claim 11, wherein the four side walls of the
mounting tube are configured to define an interior opening through the tube having a
generally square cross-sectional shape prior to the forming step.

14. (original) The method of claim 11, wherein each of the caster mounting
tubes has a square cross-sectional shape.

15. (previously presented) The method of claim 11, wherein the step of
welding the mounting tube to the base frame with first and second welds located at opposite
ends of the first side wall includes providing a two axis welding machine.

Claims 16-20 (canceled)

21. (previously presented) A patient support apparatus comprising:
a base frame;
a patient support coupled to the base frame;
a plurality of casters each having a sleeve; and
a plurality of caster mounting tubes, each mounting tube having an interior
configured to receive the sleeve of a caster, a plurality of external side walls including a
generally planar first external side wall abutting the base frame, the mounting tube being
connected to the base frame by welds located adjacent the first external side wall, wherein the
first external side wall abutting the base frame is formed to include a hole, the base frame is
formed to include a hole, the hole in the base frame being aligned with the hole in the first
external side wall, and both holes are configured to receive a movable shaft and are
positioned in spaced relation to the welds located adjacent the first external side wall.

22. (previously presented) The apparatus of claim 21, wherein each of the plurality of caster mounting tubes has a rectangular outer cross-sectional shape defined by four external side walls.

23. (previously presented) The apparatus of claim 21, wherein the sleeve of each caster has a cylindrical shape and the plurality of caster mounting tubes each include interior partially cylindrical concave wall sections configured to receive one of the sleeves.

24. (previously presented) The apparatus of claim 23, wherein each of the mounting tubes also includes a corner notch located between concave wall sections.

25. (currently amended) The apparatus of claim 7, wherein the first external side wall of each ~~caster mounting tubes are each tube is~~ is formed to include a ~~second opening hole,~~ and the base frame is formed to include a hole aligned with the hole in the first external side wall, both holes being configured to receive a movable shaft operably coupled to a brake mechanism of the caster.

26. (currently amended) The method of claim 12, further comprising the steps of forming a ~~shaft opening in~~ hole in the first side wall of the mounting tube, forming a hole in the base frame, and inserting a movable shaft into the ~~shaft opening hole in the first side wall~~ and the hole in the base frame.

27. (previously presented) The apparatus of claim 21, wherein the movable shaft is operably coupled to a brake mechanism of the caster.